

PRODUCT DATA SHEET

Acrylic Enamel 2.8 VOC

PRODUCT AT-A-GLANCE



SUBSTRATES

- OEM enamels
- Aged refinishes
- Finish 1™ sealers and surfacers



MIXING

 + 
4 Finish 1™ Color + **1** FH614, FH615 or FH616 Hardener

Hardener Selection Chart

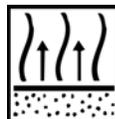
| | |
|-------|----------------|
| FH614 | 55°-75°F |
| FH615 | 70°- 90°F |
| FH616 | 85°F and above |



APPLICATION

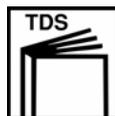
- Apply 2 medium wet coats or until hiding is achieved.
- Allow each coat to flash until hand slick.
- Adjust air pressure to:
 - 10 psi HVLP
 - 40-45 psi conventional gravity feed
 - 10-12 fluid ounces per minute and 30-35 psi w/pressure pot

*See next page for application techniques



DRYING SCHEDULE

| | | |
|---------------|--|--|
| Air dry | Out of Dust | 30 minutes @ 70° F |
| | To Deliver | Overnight or 2 hours after force dry |
| Force Dry | 30 minutes at 120° F surface temperature | |
| Buffing Times | Air Dry | After 24 hours |
| | Force Dry | 30 minutes after cool down |
| Recoat Times | Air Dry | After 24 hours followed scuffing with a gray scuff pad or P800 grit sandpaper on a random orbital sander with an interface pad |
| | Force Dry | 30 minutes after cool down followed by a scuff with a gray scuff pad or P800 grit sandpaper on a random orbital sander with an interface pad |



PHYSICAL DATA

- Pot Life: 2 hours at 75 °
- If fisheyes are a problem, add FA250 fisheye eliminator in the following amounts:
 - 2 - 6 capfuls per quart of **unreduced** color
 - 1 - 3 capfuls per quart of **ready to spray** color
 - 1 capful = 1/3 ounce or 9 grams



FINISH

AUTOMOTIVE REFINISH PRODUCTS

1

Acrylic Enamel 2.8 VOC

PRODUCT DESCRIPTION:

Finish 1™ is a high performing acrylic enamel offering bright vivid colors displaying excellent gloss and metallic control. Finish 1 acrylic enamel colors achieve 2.8 VOC when used with FH614, FH615 and FH616 hardeners. For optimum performance of Finish 1™ acrylic enamel, consult color card AS2772 for recommended sealer color for each topcoat color.

APPLICATION TECHNIQUES

Adjust air pressure to 10 psi cap pressure for HVLP, 40 - 45 psi for conventional gravity feed, and 10 - 12 fluid ounces per minute and 30-35 psi inlet atomizing pressure with a pressure pot. Apply 2 medium wet coats or until hiding is achieved, with a 50% overlap, allowing each coat to become handslick before the next coat. Apply at a gun distance of 6-8 inches. A cross-coat method (horizontal one coat, vertical the next) can be used for metallic colors to make them more uniform. If further metallic orientation is needed, after achieving hiding immediately apply a mist coat by increasing the gun distance to 10-12 inches or reducing air pressure. Recommended dry film thickness is 2.0 - 2.5 mils.



BUFFING

- If necessary, after 24 hours air dry, or 30 minute cool down from force dry, sand **Solid Colors** with 1500 or finer grit paper and buff with the appropriate compound. Buffing is easiest when done within the first 48 hours following application.
- Buffing of **Metallic Colors** may cause streaking. Only a light polishing of metallic colors is recommended with a polishing compound or glaze.



PERSONAL PROTECTION

- For use by trained professionals only.
- Read label, directions, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing, spraying, sanding or polishing

REGULATORY DATA

| | As Packaged | | As Applied | |
|------------------|-------------|-----------|------------|-----------|
| | Lb/Gal | G/L | Lb/Gal | G/L |
| Density | 7.90 | 947 | 8.35 | 1000 |
| | % by Wt. | % by Vol. | % by Wt. | % by Vol. |
| Volatiles | 51.6 | 58.8 | 50.1 | 55.6 |
| Water | 0.0 | 0.0 | 0.0 | 0.0 |
| Exempt Compounds | 20.3 | 24.3 | 15.4 | 19.5 |
| | Lb/Gal | G/L | Lb/Gal | G/L |
| VOC Total | 2.47 | 296 | 2.04 | 244 |
| VOC Less Exempt | 3.26 | 391 | 2.80 | 335 |
| | Lb/Gal | KG/L | Lb/Gal | KG/L |
| HAPs | 3.65 | 0.438 | 2.71 | 0.325 |